

Date: Tuesday, 7/18/2006 3:00:47 PM
 User: Kim Johnston

Process Sheet

Split
06/09/11

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 27968
 Estimate Number : 10327
 P.O. Number : *N/A*
 This Issue : 7/18/2006 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : MACHINED PARTS
 Previous Run : 27186
 Drawing Name : BLADE
 Part Number : D2741
 Drawing Number : D2741 REV C
 Project Number : N/A
 Drawing Revision : C
 Material : *N/A*
 Due Date : 8/15/2006 Qty: 40 Um: Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est Rev: D 00.11.15 Removed P/O turning - in house
 processEC
 Est Rev: E 06-03-20 As Per Rev C
 JLM
 Est Rev: F 06.04.20 Added grinding after heat treating EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M4130NB0500X03000 4130 Bar 0.5 x 3.0"



Comment: Qty.: 1.2118 f(s)/Unit Total : 48.4722 f(s)
 4130 BAR 0.5 x 3.0"
 Material: 4130 steel bar 0.50" x 3.00"

Batch: *M101314**J.F. 06/07/25**40*

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blanks 13.850" long +0.063" -0.000"

*J.F. 06/07/26**40*

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine per folio FA108

*Trl / J.F. 06/07/26**40*

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Drawing Name: BLADE

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Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W.F. 06/07/26

40

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

06/07/28

40

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Bend per Dwg D2741

FF 06.08.10

40

SR 06/08/09

40

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.08.11

40

8.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: *1824*

Harden material as per Dwg D2741

Min. Ultimate Tensile Strength = 152 ksi (30-40 HRC)

Min. Yield Tensile Strength = 141 ksi

Test report or Certification required

C20610811

(40)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

Ensure Test report or Certification attached

06/09/05

(40)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.09.06

(40)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Grind off carbon deposits

MF 06/09/12

(40)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE

Job Number: 27968

Part Number: D2741

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/09/12 (10)

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Grind off carbon deposits

MF 06/09/12 (10)
Please page

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

AM 06-09-12 (10)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

U 06-09-12

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

06-09-12

16.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/12 (10)

Job Completion



U 06-09-12